

Date: Wednesday, 12/7/2005 12:44:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PACKER		
Job Number	: 25155					
Estimate Number	: 10225					
P.O. Number	: N/A			Part Number	: D2150	
This Issue	: 12/7/2005		S.O. No. : N/A	Drawing Number	: D2150 REV. A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : MACHINED PARTS	Drawing Revision	: A	
Previous Run	: 24492			Material	: N/A	
Written By	: SEE COMMENT Below			Due Date	: 12/15/2005	
Checked & Approved By	: SEE APPROVAL DATE & USER			Qty:	50	Um: Each
Comment	: Est C 00.11.27 Re-format (mpp 2101) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0263 sf(s)/Unit Total : 1.3125 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M19059

55

FF 05-12-07

2.0	SHEAR	SHEAR
-----	-------	-------



55

Comment: SHEAR

Cut blank: 2.300" x 1.559" +/-0.005"

FF 05.12.07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA109 and Dwg D2150

Identify as D2150

made by Rend

06/01/30 55
06/01/30 53

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



PTO

45

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



PTO
45

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2150 PAR #: N/A Fault Category: Prod/Fab. Ass ^{metalsnap} NCR: Yes No DQA: 11 Date: 06.02.22.
 QA: N/C Closed: SJ Date: 06.02.22

NCR: <u>25155</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.31	3	8 parts scrap. holes of .171, location of dimensions are too wide, won't fit hinge, holes don't line up.	<u>AS</u> <u>06.01.31</u>	Scrap & destroy.	<u>06.01.31</u>	<u>06.01.31</u>	<u>AS</u> <u>06.01.31</u>	<u>06.01.31</u>

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:44:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 25155

Part Number: D2150

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

ml06/01/30

53

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JAD 06/02/08 45

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

AM 06-02-20

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 060220 45

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST026

P6/2/21 45

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/22 45

Q 06/02/22 45

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25155
Description: Packer	Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

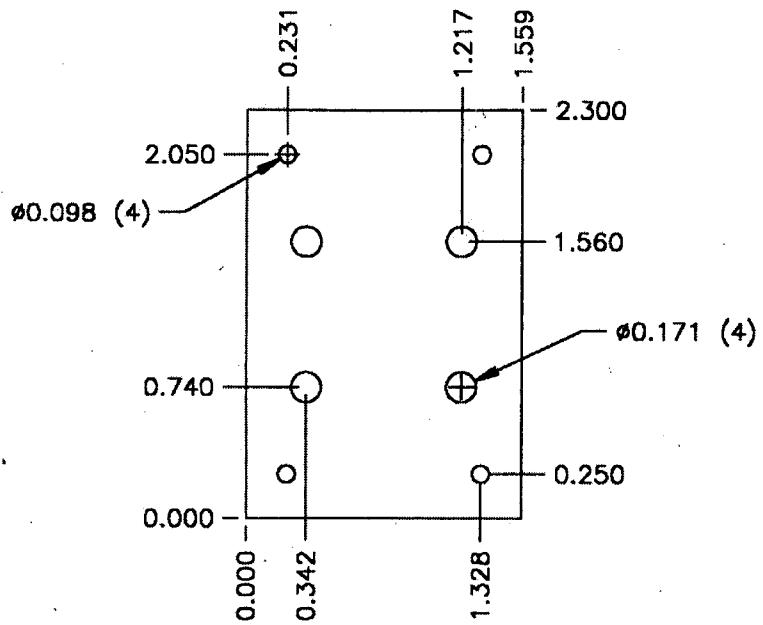
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2150
DATE 95:05:01		REV. A SHEET 1 OF 1 TITLE PACKER SCALE 1:1

RELEASED
96/06/13 BG



SHOP COPY
RETURN TO
ENGINEERING
FILE COPY
F.T.
HIC
WORK
25155

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS